

Date: Tuesday, 12/5/2006 8:15:09 AM
User: Kim Johnston

Process Sheet

split
07/01/25

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : AVIONICS RISER CONSOLE
Job Number : 29774
Estimate Number : 10259
P.O. Number : *N/A*
This Issue : 12/5/2006 S.O. No. : *N/A*
Prsht Rev. : NC
First Issue : *N/A* Type : SMALL /MED FAB
Previous Run : 29376
Written By : *[Signature]*
Checked & Approved By : *[Signature]*
Comment : Est Rev: B 05.04.11 Now made at Dart KJJ/JLM

Part Number : D212722011
Drawing Number : D3363 REV B 1
Project Number : N/A
Drawing Revision : B 1
Material : *6063-T52*
Due Date : 1/15/2007 Qty: *10* Um: Each

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels per PPP D212-722-011 CHG002

2.0 M6063T5A0750W063 Angle6063T5X.75X.75X.063



Comment: Qty.: 7.2450 f(s)/Unit Total : 72.4500 f(s)

Material: 6063-T52 Aluminum angle 3/4" x 3/4" x 0.063" wall(M6063T5A0.750W.063)

Batch: *m 17695*

m 103007 - 40' 4' ✓
m 103019 - 40' 4' ✓

3.0 M6063T5C75X75W125 6063 CHANNEL.75X.75X.125



Comment: Qty.: 0.8290 f(s)/Unit Total : 8.2900 f(s)

Material: 6063-T52 Aluminum channel 3/4" x 3/4" x 0.125" wall(M6063T5C.75x.75W.125)]

Batch: *m 17695*

10" ✓

4.0 D33631 CONSOLE



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick:

Qty Part Number Description Batch
1 D3363-1 Console (Bent) *B 29826*

ml 07/01/25

5.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Cut (2) D3360-1, (2) D3360-3 & (2) D3360-5 to length as per Dwg D3360Material: 6063-T52 Aluminum angle 3/4" x 3/4" x 0.063" wall

ml 07/01/25

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AVIONICS RISER CONSOLE

Job Number: 29774

Part Number: D212722011

Job Number:



Seq. #:

Machine Or Operation:

Description :

2-Cut (1) D3361-1 to length as per Dwg D3361 Material: 6063-T52 Aluminum channel 3/4" x 3/4" x 0.125" wall

3-Deburr D3360-1/-3/-5 & D3361-1

4-Transfer drill and C'Sink D3360-1/-3/-5 & D3361-1 from D3363-1 as per D3363. Do not rivet together

5-Deburr all parts

PTO

ml 07/01/25

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

H/L 1/2

07-01-25

(7) MORCEAUX pieces

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

ml 07/01/25

8.0

PR351

DZUS FASTENER RAIL



Comment: Qty.: 0.3333 f(s)/Unit Total: 3.3330 f(s)

Material: Dzus Fastener Rail

(PR35-1 or PR3-1/2-1)

Batch: M17763

X

9.0

MS20426AD45

Rivet



Comment: Qty.: 44.0000 Each(s)/Unit Total: 44.0000 Each(s)

Pick:

Qty Part Number

Description Batch

44 MS20426AD4-5

Rivet M4067

X44

10.0

MS20426AD46

Rivet



Comment: Qty.: 9.0000 Each(s)/Unit Total: 90.0000 Each(s)

Pick:

Qty Part Number

Description Batch

9 MS20426AD4-6

Rivet M100151

X9

11.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Cut (2) D3362-1 to length as per Dwg D3362 Material: Dzus Fastener Rail

ml 06/01/27

Step 5 — Bad Rivets — "Bad tool"
Scrap one channel and 5 rivets.
Replace Channel by new one

ml
07-01/25

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AVIONICS RISER CONSOLE

Job Number: 29774

Part Number: D212722011

Job Number:



Seq. #:

Machine Or Operation:

Description :

2-Rivet D3360-1/-3/-5 & D3361-1 & D3362-1 as per Dwg D3363
Identify as D3363-041

ml 06/01/26 x1

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07-01-26

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

14.0

PFSC3538A

Dzus 1/4 turn fastener



Comment: Qty.: 8.0000 Each(s)/Unit Total: 80.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

8 PFSC35-38A

Dzus Fastener

M19567

1 d3363-041

Console Ass

B29774

P 7/01/26

15.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

SB 07/01/26 (1)

16.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D212-722-011

M 07-01-26

P 7/01/26 (1)

17.0

QC21

FINAL INSPECTION/W/O RELEASE



(1)

Comment: FINAL INSPECTION/W/O RELEASE

P 07/01/26

Job Completion



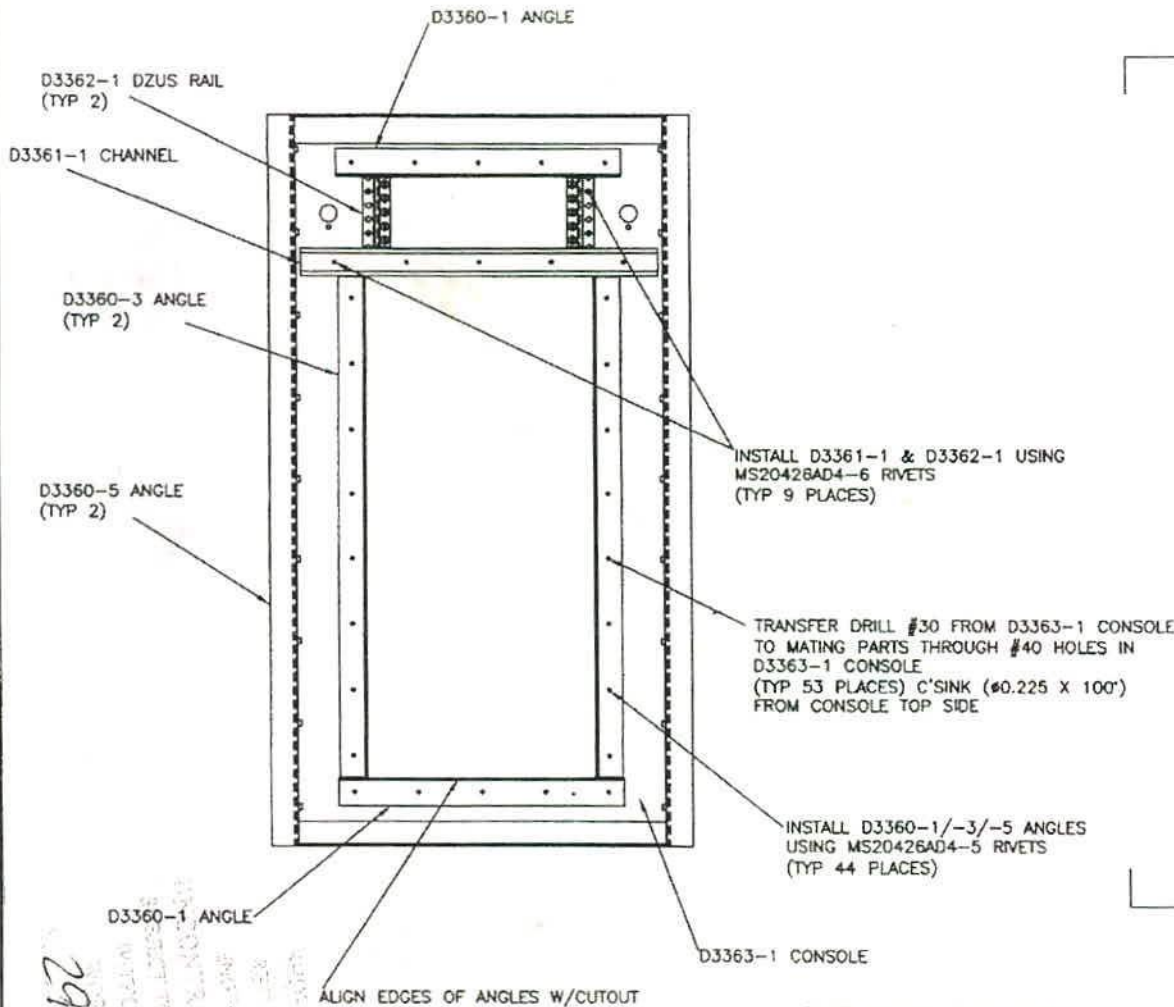
U 07-01-26

DART

RELEASED

05.03.31

DESIGN	DRAWN BY	DART AEROSPACE LTD	REV. B
PH	PH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	SHEET 1 OF 3
<i>[Signature]</i>	<i>[Signature]</i>	D3363	
DATE	TITLE	SCALE	
05.03.28	CONSOLE ASSEMBLY	1:5	
A	04.11.29	NEW ISSUE	
B	05.03.28	INCREASE WIDTH BY 0.125	
B1	05.07.28	CHANGE WIDTH TO 0.430 WAS 0.43	

C'SINK
THIS SIDE
(REF)**PARTS LIST FOR D3363-041 CONSOLE ASSEMBLY****VIEW A-A FROM UNDER CONSOLE ASSEMBLY****D3363-041 CONSOLE ASSEMBLY**

- 1) ASSEMBLE IN ACCORDANCE WITH DART QSI 002
- 2) IDENTIFY WITH DART P/N D3363-041 AND B/N BXXXXX USING FINE POINT PERMANENT INK MARKER
- 3) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1

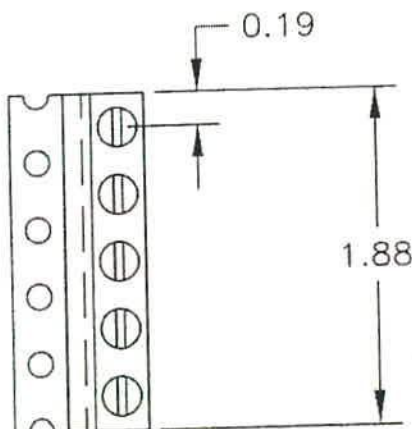
29774



DESIGN PH	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3362	REV. A SHEET 1 OF 1
DATE 04.11.29		TITLE RAIL	SCALE 1:1
A	04.11.29	NEW ISSUE	

RELEASED

05.03.31 [Signature]



D3362-1 RAIL

- 1) CUT LENGTH/SHAPE PER DIAGRAM
- 2) MAKE FROM DZUS RAIL P/N "PR 3-1/2-1" OR PR-35-1
- 3) TOLERANCES ARE PER DART QSI 018
- 4) ALL DIMENSIONS ARE IN INCHES







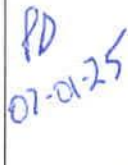



29774

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/01/26
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07-01-25	5.0	1x D3361-1 channel was scrap, due to damage from the rivet when pressing. Deep marks around the rivet hole.	 QS1042	Scrap, destroy & replace.	 07/01/25	 07-01-25	 QS1042	 07-01-25
07-01-25	11.0	During riveting the tool damaged the top of the D3361-1 channel.	 QS1042	Fill affected area with weld as per QS1004, grind flush, and touch up with Alodine as per QS1005.	 07-01-25	 07-01-25	 QS1042	 07-01-25

NOTE: Date & initial all entries

Process Sheet

Dart Aerospace Ltd.

Split 07/02/27

Customer : CU-DAR001 Dart Helicopters Services
Job Number : 29774
Estimate Number : 10259
P.O. Number :
This Issue : 12/5/2006 S.O. No. :
Prsht Rev. : NC
First Issue : 1/1 Type : SMALL / MED FAB
Previous Run : 29376
Written By :
Checked & Approved By :
Comment : Est Rev: B 05.04.11 Now made at Dart KJ/JLM

Drawing Name : AVIONICS RISER CONSOLE
Part Number : D212722011
Drawing Number : D3363 REV B 1
Project Number : N/A
Drawing Revision : B 1
Material :
Due Date : 1/15/2007
Qty: 10 Um: Each

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL
Photocopy bluefile and create labels per PPP D212-722-011 CHG002

2.0 M6063T5A0750W063 Angle6063T5X.75X.75X.063



Comment: Qty.: 7.2450 f(s)/Unit Total: 72.4500 f(s)
Material: 6063-T52 Aluminum angle 3/4" x 3/4" x 0.063" wall(M6063T5A0.750W.063)
Batch:

M103007 - 40
M103019 - 40

3.0 M6063T5C75X75W125 6063 CHANNEL.75X.75X.125



Comment: Qty.: 0.8290 f(s)/Unit Total: 8.2900 f(s)
Material: 6063-T52 Aluminum channel 3/4" x 3/4" x 0.125" wall(M6063T5C.75x.75W.125)
Batch: m 17695

M17080
X9

4.0 D33631 CONSOLE



Comment: Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)

Pick:

Qty Part Number Description Batch
1 D3363-1 Console (Bent) B29826

X9

5.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Cut (2) D3360-1, (2) D3360-3 & (2) D3360-5 to length as per Dwg D3360Material: 6063-T52 Aluminum
angle 3/4" x 3/4" x 0.063" wall

m 07/02/01

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AVIONICS RISER CONSOLE

Job Number: 29774

Part Number: D212722011

Job Number:



Seq. #:

Machine Or Operation:

Description :

2-Cut (1) D3361-1 to length as per Dwg D3361 Material: 6063-T52 Aluminum channel 3/4" x 3/4" x 0.125" wall

3-Deburr D3360-1/-3/-5 & D3361-1

4-Transfer drill and C'Sink D3360-1/-3/-5 & D3361-1 from D3363-1 as per D3363. Do not rivet together

5-Deburr all parts

ml07/02/01

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

FL/48

07/02/05

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

8.0

PR351

DZUS FASTENER RAIL



Comment: Qty.: 0.3333 f(s)/Unit Total: 3.3330 f(s) (5.999) F.

Material: Dzus Fastener Rail

(PR35-1 or PR3-1/2-1)

Batch: M17763

X 18

9.0

MS20426AD45

Rivet



Comment: Qty.: 44.0000 Each(s)/Unit Total: 440.0000 Each(s) (396)

Pick:

Qty Part Number

Description

Batch

44 MS20426AD4-5

Rivet

M4067

PTO

10.0

MS20426AD46

Rivet



Comment: Qty.: 9.0000 Each(s)/Unit Total: 90.0000 Each(s) (81)

Pick:

Qty Part Number

Description

Batch

9 MS20426AD4-6

Rivet

M100151

11.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



PTO

Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Cut (2) D3362-1 to length as per Dwg D3362 Material: Dzus Fastener Rail

ml07/02/26 x9

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AVIONICS RISER CONSOLE

Job Number: 29774

Part Number: D212722011

Job Number:



Seq. #: Machine Or Operation:

Description :

2-Rivet D3360-1/-3/-5 & D3361-1 & D3362-1 as per Dwg D3363
Identify as D3363-041

ml 07/02/26 x9

12.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07/02/27

13.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

14.0 PFSC3538A

Dzus 1/4 turn fastener



Comment: Qty.: 8.0000 Each(s)/Unit Total : 80.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

8 PFSC35-38A Dzus Fastener M19567

1 d3363-041 Console Ass 329774

07/2/27 (2)

15.0 QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

07/02/27 (2)

16.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D212-722-011

MLC 02/17/27 (2)

17.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



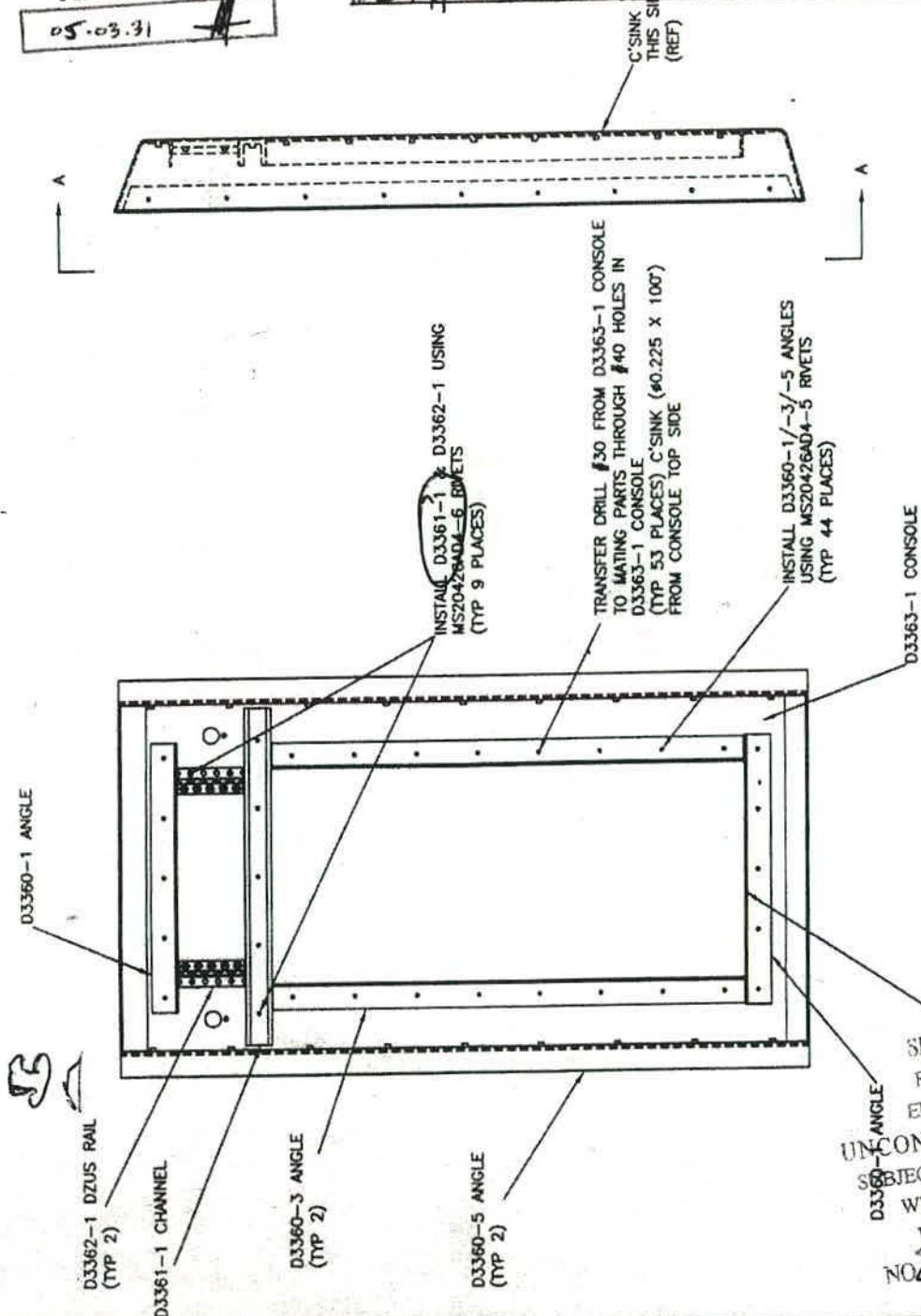
07/02/27

DART

RELEASED

05-03-31

DESIGN PH	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3363	REV. B SHEET 1 OF 3
DATE 05.03.28	TITLE CONSOLE ASSEMBLY	SCALE 1:5	
A	04.11.29	NEW ISSUE	
B	05.03.28	INCREASE WIDTH BY 0.125	
B1	05.04.28	CHANGE WIDTH TO 10.430, WAS 10.43	



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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO 29774

- D3363-041 CONSOLE ASSEMBLY
- 1) ASSEMBLY IN ACCORDANCE WITH DART QSI 002
 - 2) IDENTIFY WITH DART P/N D3363-041 AND B/N BXXXXX USING FINE POINT PERMANENT INK MARKER
 - 3) FINISH-ACID ETCH AND ALCOONE PER DART QSI 005 4.1

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